



Dart Aerospace Ltd.
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Canada

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D3453-3

Job Sheet 190457



Part No: D3453-3

Job Qty: 4 pcs

Part Name: Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B A 05.09.27 New issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	4 pcs	2/28/19	2/28/19	0.62	2.73	Doosan - 1		
160	QC 8	4 pcs	2/28/19	2/28/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 47		
170	Packaging 3-1 - Stock - B4B	4 pcs	2/28/19	2/28/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		



Container No: S158458



Part: D3453-3

Job No: 190457

Serial No/Batch: S158458

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 03/04/19

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				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				QC 21 - SA - 21	540
				QC 21 - SA - 70	21
				QC 21 - SA - 53	3-00
180 QC 21 - SA	4 pcs	2/28/19	0.00 0.00		

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Part Op 100 - (Doosan Lathe), 1-Turn as per Folio FA578 Rev: _____ & Dwg D3453 Rev: _____
 Descriptions: 160 - (QC8- Inspect parts - second check)
 170 - (Identify as per dwg & Stock Location: _____), *****STOCK IN LARGE FAB*****
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.250	304 Round Bar 1.250	.9808 ft (.2452 ea) 308 ea	100-Doosan - 1	5099656

12.1
175/8

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R1.250	1	8	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clevis	1.130inches $\pm$ 0.030	1.160 1.100	1.13	
2	Clevis	0.755inches $\pm$ 0.002 - 0.005	0.757 0.750	.7545	
3	Clevis	2.740inches $\pm$ 0.030	2.770 2.710	2.738	
4	Clevis	1.220inches $\pm$ 0.010	1.230 1.210	1.2195	
5	Clevis	1.000inches $\pm$ 0.030	1.030 0.970	1.0	
6	Clevis	0.500inches $\pm$ 0.010 - 0.000	0.510 0.500	.5075	
7	Clevis	0.375inches $\pm$ 0.006 - 0.001	0.381 0.374	.376	
8	Clevis	0.129inches $\pm$ 0.005 - 0.001	0.134 0.128	.1295	
9	Clevis	0.625inches $\pm$ 0.010	0.635 0.615	.630	
10	Clevis	0.450inches $\pm$ 0.010	0.460 0.440	.448	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					